

Work Order ID 72571

Friday, July 29, 2011 1:35:23 PM

Page 1

Item ID: D4334-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 7/29/2011 Start Qty: 3.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4334

A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

BAP

EP 9/08/11 (3)

EP 11/08/11 (3)

S 11/08/11

(43)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 72571

Friday, July 29, 2011 1:35:23 PM



Page 2

Item ID: D4334-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 7/29/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/21/11 SP (30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/11

MCF
11-08-11

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 09, 2011 11:29:18 AM

Page 1

Work Order ID: 72571

Parent Item: D4334-041

Parent Item Name: Bracket Assembly






Start Date: 7/29/2011

Required Date: 8/2/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| 90296A208  Heli-Coil Insert | | Purchased | No | | | | Each | 3.0000 | | 3 | | 8/11/08/11 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST | | | | 3 | | | | | |
| | | | | | 117212 | | | 3 | | | | | |
| AN4-5A  Bolt | | Purchased | No | | | | Each | 227.0000 | | 3 | | 8/11/08/11 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST355 | | | | 200 | | | | | |
| | | | | | 117508 | | | 200 | | | | | |
| | | | | ST356 | | | | 27 | | | | | |
| | | | | | 116549 | | | 27 | | | | | |
| D4334-1  Swivel | | Manufactured | No | | | | Each | 0.0000 | | 3 | | 8/11/08/11 | |
| D4334-3  Base | | Manufactured | No | | | | Each | 0.0000 | | 3 | | 8/11/08/11 | |
| MS35333-125  Lock Washer | | Purchased | No | | | | Each | 300.0000 | | 3 | | 8/11/08/11 | |
| | | | | <u>Location</u> | | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | |
| | | | | ST295 | | | | 300 | | | | | |
| | | | | | 117107 | | | 300 | | | | | |

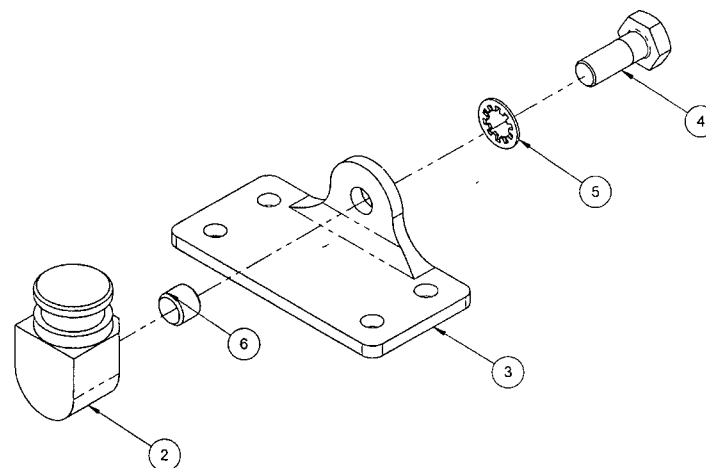
B 72711

(3x)

B 72712

(3x)

| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|------------------|
| 1 | X | D4334-041 | BRACKET ASSEMBLY |
| 2 | 1 | D4334-1 | SWIVEL |
| 3 | 1 | D4334-3 | BASE |
| 4 | 1 | AN4-5A | BOLT |
| 5 | 1 | MS35333-125 | LOCK WASHER |
| 6 | 1 | 90296A208 | HELI-COIL |



D4334-041 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72571

11-07-29

RELEASED
2011-05-20

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.10 LBS

| REV. | NEW ISSUE | DESCRIPTION | BY | DATE |
|------------|-----------|-------------|----|------|
| DESIGN | | | | |
| DRAWN | | | | |
| CHECKED | | | | |
| MFG. APPR. | | | | |
| APPROVED | | | | |
| DE APPR. | | | | |
| DATE | 11.04.18 | | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4334** REV. A
SHEET 1 OF 11
TITLE **BRACKET** SCALE NTS

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| W/O: | | WORK ORDER CHANGES | | | | | |
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